

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-022338**Date Inspected:** 21-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Kelly Leavitt, was present during the times noted above for random observations relative to the work being performed.

Bay 14

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Wang Ziong Ping, CWI Wang Jun.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Components; OBG 14 W

PCMK: SEG3020AG

Weld No: 063

Welder: 045246

WPS-B-P-2214-TC-U4b-FCM-1

Components; OBG 14 W

PCMK: DP3168-001

Weld No: 040,039

Welder: 067588

WPS-B-P-2213-TC-U4b-FCM-1

WELDING INSPECTION REPORT

(Continued Page 2 of 4)

Components; OBG 14 W, PP127
PCMK: SEG3020L
Weld No: 162,163,165,166,167,168
Welder: 067993
WPS-B-P-2113-TC-U4b-FCM-1

Components; OBG 14 W
PCMK: SEG3020BB
Weld No: 002
Welder: 067609
WPS-B-P-2212-TC-U4b-FCM-1

This QA Inspector observed the following work in progress for Bay 14.
ZPMC was using the Flux Core Arc Welding (FCAW) process.
ZPMC QC is identified as Wang Ziong Ping, CWI Wang Jun.
Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).
Listed below are the locations that were identified by this QA inspector.

Components; OBG 14 W
PCMK: DP3168-001
Weld No: 121,125,117
Welder: 067876
WPS-B-T-2233-ESAB

Components; OBG 13CW
PCMK: SA3232B
Weld No: 009
Welder: 048433
WPS-B-T-2233-ESAB

Components; OBG 13BW
PCMK: SEG3014G
Weld No: 014
Welder: 054143
WPS-B-T-2233-ESAB

Components; OBG 14 W
PCMK: SA3416-001
Weld No: 049
Welder: 201513
WPS-B-T-2232-ESAB

This QA Inspector observed the following work in progress for Bay 14.

WELDING INSPECTION REPORT

(Continued Page 3 of 4)

ZPMC was using the Submerged Arc Welding (SAW) process.

ZPMC QC is identified as Wang Ziong Ping, CWI Wang Jun.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Components; OBG 14 W

PCMK: SEG3020AQ

Weld No: 030

Welder: 045270

WPS-B-T-2221-B-L2C-S-2

This Caltrans QA Inspector observed at random intervals, six ZPMC employees, performing grinding of welds located in Segment 14 West SA3146C at various locations due to contour grinding and visual indications as identified by ZPMC QC Inspectors.

This Caltrans QA Inspector observed at random intervals, seven ZPMC employees, performing grinding of welds located in Segment 14 West DP3168 at various locations due to contour grinding and visual indications as identified by ZPMC QC Inspectors.

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Zhong Yong Gang, CWI Bao Gian.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Components; OBG 13BE

PCMK: SEG3009E

Weld No: 207

Welder: 051359

WPS-B-P-2213-TC-U4b-FCM-1

Components; OBG 13BE

PCMK: SEG3009J

Weld No: 012,013

Welder: 051359

WPS-B-P-2213-TC-U4b-FCM-1

Components; OBG 14 E, Fit Up

PCMK: SEG3019BB (see photo below)

Weld No: 001

Welder: 067993

WPS-B-P-2214-Fit Up

Components; OBG 14 E, Stiffener Plate

WELDING INSPECTION REPORT

(Continued Page 4 of 4)

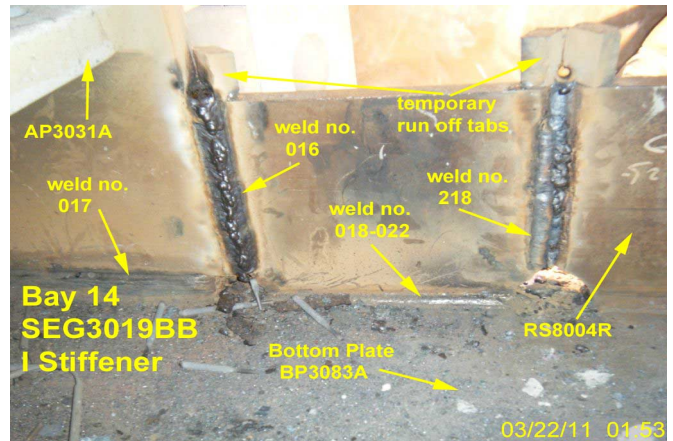
PCMK: SEG3019BB (see photo below)

Weld No: 016,218

Welder: 216086

WPS-B-P-2213-TC-U4b-FCM-1

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

"No relevant conversations."

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey 1500026784, who represents the Office of Structural Materials for your project.

Inspected By: Leavitt,Kelly

Quality Assurance Inspector

Reviewed By: Riley,Ken

QA Reviewer